



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Kush

647.7812
Job Sheet 170172



Part No: 647.7812

Job Qty: 6 ea

Part Name: Center Plate, Upper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/11/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 2/2/18

Type: SOLD

Description:

Note: DWG REV A IPP REV A RQ 14/1/07 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/1/18	0.00	0.00	Start Up Machining-1		<i>SC 18/01/18</i>
100	Bandsaw	6 pcs		2/1/18	0.00	0.00	Bandsaw1		<i>SC 18/01/18</i>
110	CNC Vertical Machining	6 pcs		2/2/18	0.00	4.79	HAAS1-1		<i>SC 18/01/18</i>
120	QC	6 pcs		2/2/18	0.00	0.00	QC2 Machining-1		<i>SC 18/01/18</i>
130	QC	6 pcs		2/2/18	0.00	0.00	QC8 Machining-1		<i>SC 18/01/18</i>
140	Outsource	6 pcs		2/2/18	0.00	0.00	Outsource4		
150	Packaging	6 pcs		2/2/18	0.00	0.00	Packaging2		
160	QC	6 pcs		2/2/18	0.00	0.00	QC5		<i>D 18.01.18</i>
180	Packaging	6 pcs		2/2/18	0.00	0.00	Packaging3-1	<i>CK 14</i>	
190	QC21-SA	6 Ea		2/2/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 4.875"

Descriptions: 110 - 1-Machine per folio FB235 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges
140 - Issue P/O to ATG : *038802* 1- Black Anodize as per Dwg 647.7800 2- PRIME AS PER DWG, SEE NOTE #2
Certification of Conformity is required
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
JAN 17 2017 *LENB*

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B0.750X4.000	2	7	0	0

5032491

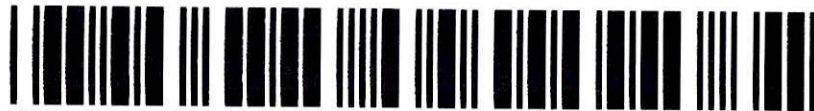
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Center Plate Upper	1.000inches ± 0.005	1.005 0.995		
2	Center Plate Upper	3.000inches ± 0.005	3.005 2.995		
3	Center Plate Upper	1.160inches ± 0.005	1.165 1.155		
4	Center Plate Upper	3.171inches ± 0.005	3.176 3.166		
5	Center Plate Upper	3.072inches ± 0.005	3.077 3.067		
6	Center Plate Upper	0.231inches ± 0.005	0.236 0.226		

DART
AEROSPACE
S032493

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Center Plate, Upper

PART NO: 647.7812

Original Serial #: S032493

Revision:

Operation: Start up Operation 01/16/18

Change No:

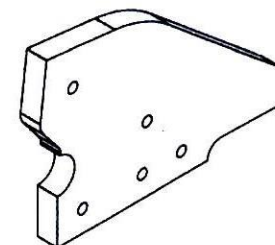
Job No: 170172

7	Center Plate Upper	0.375inches $\pm$ 0.002	0.377 0.373	
8	Center Plate Upper	96.500Degrees $\pm$ 0.500	97.000 96.000	Angle
9	Center Plate Upper	6.500Degrees $\pm$ 0.500	7.000 6.000	Angle
10	Center Plate Upper	39.600Degrees $\pm$ 0.500	40.100 39.100	Angle
11	Center Plate Upper	0.325inches $\pm$ 0.005	0.330 0.320	Radius
12	Center Plate Upper	0.125inches $\pm$ 0.005	0.130 0.120	Radius
13	Center Plate Upper	0.177inches $\pm$ 0.005	0.182 0.172	Diameter
14	Center Plate Upper	2.575inches $\pm$ 0.002	2.577 2.573	
15	Center Plate Upper	2.475inches $\pm$ 0.002	2.477 2.473	
16	Center Plate Upper	2.380inches $\pm$ 0.002	2.382 2.378	
17	Center Plate Upper	0.400inches $\pm$ 0.002	0.402 0.398	
18	Center Plate Upper	1.250inches $\pm$ 0.002	1.252 1.248	
19	Center Plate Upper	1.160inches $\pm$ 0.002	1.162 1.158	
20	Center Plate Upper	1.220inches $\pm$ 0.002	1.222 1.218	
21	Center Plate Upper	0.500inches $\pm$ 0.002	0.502 0.498	

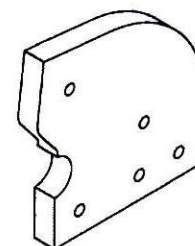
Plex 1/11/18 9:53 AM dart.poulin.mario

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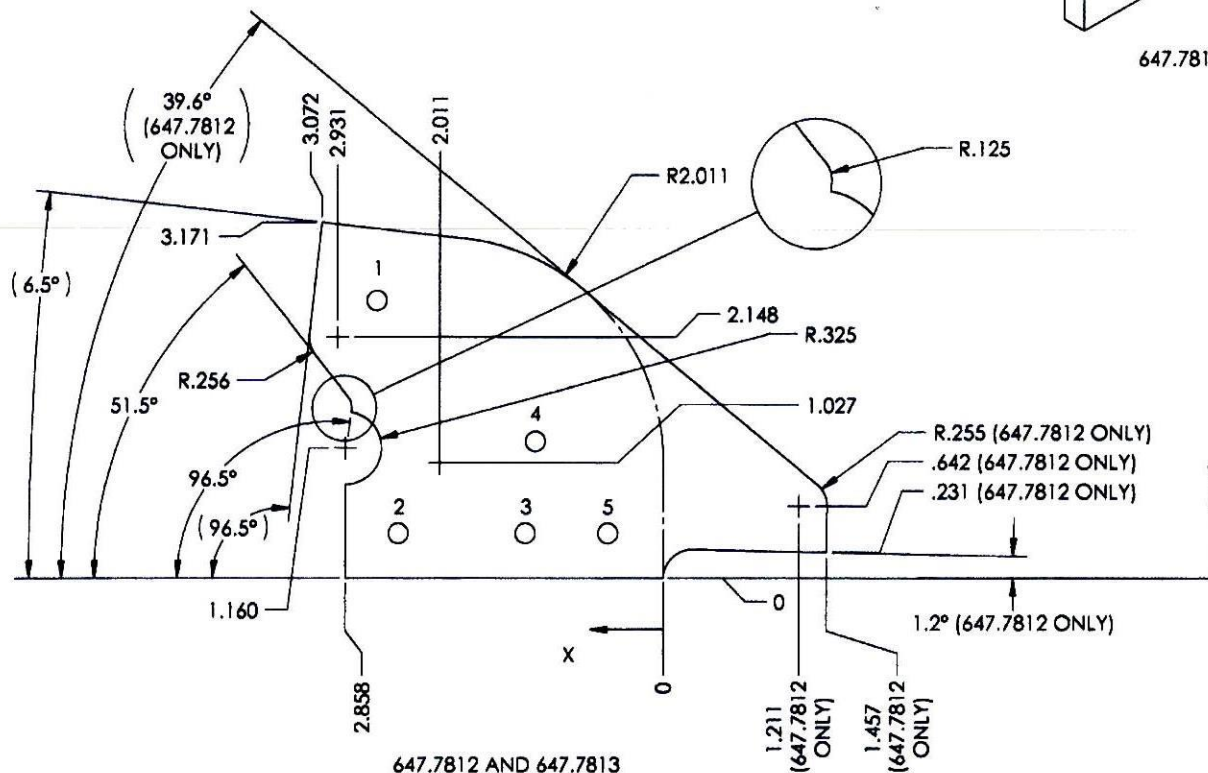
TAG	X LOC	Y LOC	SIZE
1	2.575±.002	2.475±.002	Ø.177 THRU
2	2.380±.002	.400±.002	Ø.177 THRU
3	1.250±.002	.400±.002	Ø.177 THRU
4	1.160±.002	1.220±.002	Ø.177 THRU
5	.500±.002	.400±.002	Ø.177 THRU



647.7812



647.7813



647.7812 AND 647.7813

ORIGINAL DATE: 11-08-02		3030 ENTERPRISE CT.	
DRAWN BY: CRICKER		SUITE A	
APPROVED BY: P. BRAYO		VISTA, CA 92081	
DRAWING APPROVAL: P. BRAYO		(760) 724-5500	
CONTRACT NO.		APICAL INDUSTRIES INC.	
UNLESS OTHERWISE SPECIFIED		DART AEROSPACE	
DIMENSIONS ARE IN INCHES		RES DART AEROSPACE	
TOLERANCES ARE:		BRACKET	
1 PLACE DECIMAL: .010		REV A	
2 PLACE DECIMAL: .005		SCALE: NONE	
ANGLES: .5°		1 SHEET 3 OF 10	



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914470

Date: 22-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
20 ea	Part: D2348 Wearplate (Key Way) Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils). Job: 22342 PO: PO038802 Line: 1	Rev: C	
10 ea	Part: 647.7811 Bracket B Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22343 PO: PO038802 Line: 2	Rev: A	
6 ea	Part: 647.7812 Center Plate, Upper Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22344 PO: PO038802 Line: 3	Rev: A	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>24/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada			